DRAWING NO.
DCAJ424

D or E

SUCTION or PROCESS - COPPER
O.D. - .498-.502 [12.6-12.8]
WALL - .0545-.0615 [1.4-1.6]
END I.D. - .378-.381 [9.6-9.7]
X .865-.927 [22.0-23.5]
PLUG, -4

0.455 - 0.580
[11.6 - 14.7]

50°
40°

R 8.276 - 8.339
[210.2 - 211.8]

4.793 - 4.833
[121.7 - 122.8]

2.958 - 3.458
[75.1 - 87.8]

Ø 0.750 - 0.760
[19.05 - 19.30]
(4) HOLES

1.969 - 2.219
[50.0 - 56.4]

R 2.401 - 2.464
[61.0 - 62.6]

43°
33°

4.563 - 4.813
[115.9 - 122.2]

R 13.276 - 13.339
[337.2 - 338.8]

8.490 - 8.678
[215.7 - 220.4]

2.313 - 2.813
[58.7 - 71.4]

6.946 - 7.008
[176.4 - 178.0]

4.656 - 4.906
[118.3 - 124.6]

7.969 - 8.031
[202.4 - 204.0]

R 0.594 - 0.656
[15.1 - 16.7]

43°
33°

0.455 - 0.580
[11.6 - 14.7]

2.531 - 2.594
[64.3 - 65.9]

2.063 - 2.313
[52.4 - 58.8]

5.116 - 5.178
[129.9 - 131.5]

6.445 - 6.633
[163.7 - 168.5]

40°
50°

D or E

SUCTION or PROCESS - COPPER
O.D. - .498-.502 [12.6-12.8]
WALL - .0545-.0615 [1.4-1.6]
END I.D. - .378-.381 [9.6-9.7]
X .865-.927 [22.0-23.5]
PLUG, -4

DISCHARGE - COPPER
O.D. - .373-.377 [9.5-9.6]
WALL - .0545-.0615 [1.4-1.6]
END I.D. - .253-.256 [6.4-6.5]
X .500 [12.7] MIN.
PLUG, -2 HAND FORM

4.159 - 4.534
[105.6 - 115.2]

A

B

C

0.157 - 0.219
[4.0 - 5.6]
(2) BRK'TS

7.750 - 7.813
[196.8 - 198.5]

9.897 - 10.022
[251.4 - 254.5]

DIMENSIONING = INCHES / MILLIMETERS OR INCHES [MILLIMETERS]

3D,VNX6

NOTE:
1. IF SPECIFIED ON BILL OF MATERIAL ASSEMBLE THESE PARTS AS SHOWN.
2. SEE SPEC. "A-B" & "A-C" FOR PROCESSING.
3. SEE DWG. #AHTI FOR ASSEMBLY OF DISCHARGE CONNECTOR AND LOWER SHOCK LOOP IN LOWER HOUSING.
▲4. MUST COMPLT WITH T.P.Co. GLOBAL SPEC 08.

A	HA635-8
B	HA634
Ⓒ C	34366
D	34372
E	34372

ENGLISH

O.A. SYMBOLS
★ = CATEGORY I
▲ = CATEGORY II
■ = CATEGORY III
= CATEGORY IV

AJ

LT	LC	CHANGE	DATE
D	—	EC41943 REDRAWN IN 3D NO CHANGE #228106-1	TS 17JAN12
C	6A	REMOVED HA-536-102 & HA-535	N.L.C. 8-14-95
B	—	REDRAWN- NO CHANGE, ON TO CAD #220833	HMB 10/14/92

THIS DRAWING OR PRINT (I) IS THE PROPERTY OF TECUMSEH PRODUCTS COMPANY AND CONTAINS PROPRIETARY AND CONFIDENTIAL INFORMATION OWNED BY TECUMSEH. (II) THIS MADE AVAILABLE TO THE RECIPIENT ON THE EXPRESS AND IMPLIED UNDERSTANDING THAT THE RECIPIENT WILL NOT USE IT OR DISCLOSE IT TO OTHERS WITHOUT THE EXPRESS AND WRITTEN CONSENT OF TECUMSEH AND THAT SUCH INFORMATION WILL BE USED ONLY IN A MANNER APPROVED IN WRITING BY TECUMSEH. (III) NOTHING IN THIS DRAWING OR PRINT SHALL BE CONSTRUED AS GRANTING OR CONFERRING BY IMPLICATION, ESTOPPEL OR OTHERWISE ANY LICENSE OR RIGHT UNDER ANY PATENT OWNED OR CONTROLLED BY TECUMSEH, EXCEPT IN THE MANNER AND TO THE EXTENT EXPRESSLY AUTHORIZED IN WRITING BY TECUMSEH. (IV) SPECIFIC WRITTEN CONSENT AND APPROVAL IS REQUIRED BEFORE ANY SUCH INFORMATION SHALL BE RETURNED BY THE RECIPIENT TO ANY EXTENT NOT PREVIOUSLY AUTHORIZED IN WRITING. (V) UPON THE LATTER'S REQUEST PROMPTLY AFTER SUCH REQUEST IS MADE.

DO NOT SCALE THIS DRAWING AS VARIOUS MATERIALS MUST NOT BE MAGNETIZED AS WELDED OR AFTER COMPRESSOR ASSEMBLY.

DIS.CODE 34D

NAME SALES COMPRESSOR

DWN.	CK.	APR.	SCALE
BRODERICK 10/14/92	M'CAUGHEY 8-15-95	BLANDEN	1:2 & NOTED

THIS PRINT SUPERSEDES ALL PRINTS PRIOR TO

TECUMSEH PRODUCTS CO.
ANN ARBOR, MICHIGAN

MATERIAL NOTED

DRAWING NO. DCAJ424

BANNER